

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005975**Date Inspected:** 28-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Guo Yan Fei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG &**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Larry Viars was present during the times noted above for observations relative to the work being performed.

Bay 9-

Gantry 1 / PMT 1

The Caltrans QA Inspector monitored the OBG Production Monitoring Test (PMT) for Deck Panels DP402-001 (11CE) and 456-001 (11CE). The Caltrans QA inspector recorded amperage, voltage and travel speed of the Gas metal Arc Welding (GMAW) root pass and the Submerged Arc Welding (SAW) cover pass. A Visual inspection of the fit up, tack welds, root pass and cover pass was performed by ZPMC QC Guo Yan Fei, American Bridge Flour (ABF) Cao Hai Zhou and the Caltrans QA. The Caltrans QA observed ZPMC QC Xu Wei performed Ultrasonic testing of the Partial Joint Penetration weld for depth of penetration. Mr. Xu found the depth of penetration of the PMT welds to be in compliance with contract documents. The Caltrans QA inspector designated locations for Macroetch samples (15 locations). Macroetch samples were evaluated with a 7x optical comparator and accepted by ZPMC QC, ABF QC and the Caltrans QA Inspector.

ZPMC performed MT of excavation areas of tack welds for DP402-001 and DP456-001 tack welds and found them to be acceptable.

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## WELDING INSPECTION REPORT

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Bay 12-

This QA Inspector performed Phased Array Ultrasonic Testing (PAUT) of OBG deck panel u-rib Partial Joint Penetration (PJP) welds at tack weld locations after weld repair. Testing was performed in accordance with Caltrans UT procedure “ Phased Array Testing for detection of planar discontinuities (cracks) in PJP welds.

Results of Deck Panels evaluated are as follows:

DP332-001: 2 locations tested with 2 accepted (R4).

DP249-001: 4 locations tested 1 rejected (R5).

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

Only general conversations occurred between QC and QA on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150 0042 2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Viars,Larry	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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